

Work Order ID 130312

Wednesday, March 04, 2015 1:02:52 PM

130312

Page 1

Item ID: D4007-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Top Support Bracket
 Start Date: 3/4/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 3/25/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: mf Date: 15-3-4 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4007	A

100

100

Purchasing

Purchasing

Memo

Issue P/O: 27659
 Purchase part as per Dwg D4007
 Possible Supplier: GFI
 Material release note required

0.00

0.00

CA 15/03/04 (4)

110

110

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

Memo

0.00

0.00

4x 8015-03-28

120

120

QC

Quality Control

QC6- Inspect dimensions to drawing

Memo

0.00

0.00

(4)

DAG
38
9-89

MAR 26 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				4	15-4-7		
130	HandFinish	0.00							
	Memo								
	Hand Finishing								
140	QC3- Inspect Part Finish	0.00				4			DAS 38 9-89
140	QC	0.00							
	Memo								
	Quality Control								APR 09 2015
150	Identify as per dwg & Stock Location: <u>store</u>	0.00				4			
150	Packaging	0.00							DAS 27 9-89
	Memo								
	Packaging								

APR 09 2015

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-05

PS-49

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

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Page 1

Work Order ID: 130312

130312

Parent Item: D4007-1

D4007-1

Parent Item Name: Top Support Bracket

Start Date: 3/4/2015

Required Date: 3/25/2015

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP rev A 09.12.18 new Issue Prelim EC verified: DD
10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4007-1P		Purchased	No			110	Each	0.0000	1	4			
D4007-1P Top Support Bracket **  SP 15-04-9													

DQA: _____ Date: _____



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Work Order update only ☐

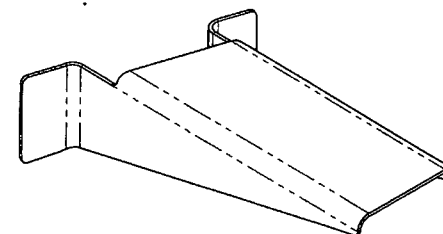
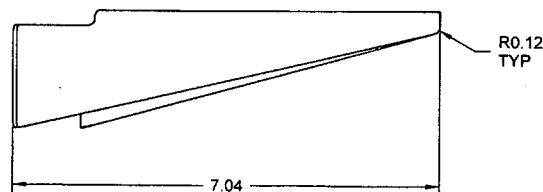
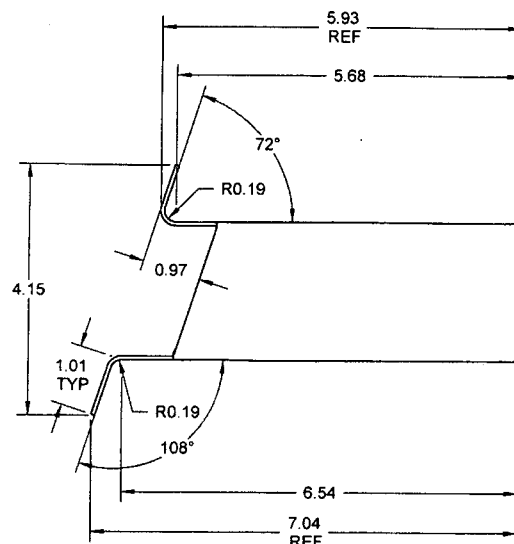
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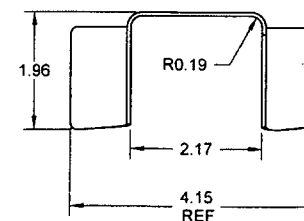
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4007-1	JCA-M47-2-02



mf
130312
15-3-15



D4007-1 TOP SUPPORT BRACKET

RELEASED
2010-05-05
mf

NOTES:

- 1) MATERIAL: MADE FROM D4007-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4007-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.17 lbs

A NEW ISSUE		BY DATE	
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>mf</i>		
DRAWN	<i>mf</i>		
CHECKED	<i>mf</i>		
MFG. APPR.	<i>mf</i>		
APPROVED	<i>mf</i>		
DE APPR.	<i>mf</i>		
DATE	10.02.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 5
DRAWING NO. D4007		TITLE	SCALE
SUPPORT			NTS
COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27659**

Purchase Order Date 3/4/2015

PO Print Date 3/4/2015

Page Number 1 of 2

Order From :

VC-GFI001

Ship To : DART AEROSPACE LTD

GFI
180 AVENUE LABROSSE
POINTE CLAIRE, QC H9R 1A1
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 514 630 4877

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4007-1P AS PER DWG D4007 REV. A B130312	Top Support Bracket	3/27/2015 Yes 3/27/2015		4.00 Each	\$80.00	\$320.00
Line Total:							\$320.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	3/27/2015 No 3/27/2015		1.00	\$0.00	\$0.00
PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE) A026 CERTIFICATION OF MATERIAL CONFORMANCE A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT							

Note:

3/4/2015



180 AVENUE LABROSSE
POINTE-CLAIRE, QC, CANADA H9R 1A1
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited



BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON SHIPPING MEMO NO	PAGE
JR - DY	MO - MO	AN - YR		
23	03	15	0556637	1/1



VENDU À / SOLD TO

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

CODE DE CLIENT CUSTOMER CODE	N° DE CONTRAT JOB NO	VOTRE N° DE COMMANDE YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART GFI-0299	0300482	PO27659	

QUANTITÉ QUANTITY	N° DE PIÈCE PART NO	DESCRIPTION
----------------------	------------------------	-------------

4 D4007-1P

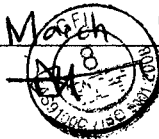
SUPPORT

ITEM 1
C OF C REQ'D

Sp/503-28

MFG. JOB# 0300482-001 QTY 4 pas

DUE DATE: 27 March 2015



EXPÉDITEUR
SHIPPER

REÇU PAR / RECEIVED BY

DATE

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE 5 JOURS DE LA RÉCEPTION
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas&Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 3 OUR JOB NO 0300482 SHIPPING MEMO 0556637

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
--	4 PCS	PO27659	D4007-1P	A	SUPPORT	A
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
AL 2024-T3		SAMUEL / KAISER ALUMINUM		109604B9		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2	REF. GFI MANUFACTURING JOB NUMBER 0300482-001 (4 PCS).		
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 23 MARCH 2015

G.F.I. Q.C. REP. *Robert Han*





180 Labrosse Av.
Pointe Claire, QC
H9R 1A1

TO:

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON
K6A 1K7

(CPO) PO#:

PO27659



(POI) ITEM#:

0001



PACKAGE COUNT:

1 OF 1

(PNR) PART NUMBER:

D4007-1P



(SHQ) QUANTITY:

4



PACKAGE WEIGHT:

(UNT) UNIT OF MEASURE:

EA



(PSN) PACKING SLIP #:

0556637



(COO) ORIGIN:

CA



(NAF) NAFTA:



(TRA) TRACEABILITY #:

0300482-001





LES METAUX SPECIALISES SAMUEL
21525 CLARK-GRAHAM
BAIE D'URFE, QUEBEC, CANADA
H9X 3T5
(514) 457-3399 T     (514) 457-9393

No 003449065



PAGE 1 DE/OF 1

TRANSPORTEUR/CARRIER NAME
CASTERO R-571041-4

CANON/TRUCK 099 NOM DE LA BRANCHE/SALES BRANCH NAME
SAMUEL & FILS & CIE LT   

DATED/EXP/DATE OF SHIPMENT
1/26/15

VENDU   /SOLD TO:
GFI, DIVISION DE THOMAS & BETTS L    
180 LABROSSE

EXP       /SHIP TO: FAB: DEST
GFI INC.
180 LABROSSE

POINTE-CLAIRE
QC
H9R1A1

(514) 630-4877

POINTE-CLAIRE
QC
H9R1A1

CA

(0201009-00001)

N        
N        
302892-01

DESCRIPTION ET POIDS/DESCRIPTION AND WEIGHT

#Comm du client: 85396

Cert/Test: FAX

5 PCS 2024 T3 BARE QQA250/4

218 LVR

.0630"x48"x144"

AMS-QQA-250/4

C OF C + MILL TESTS REQUIRED.

#Pi     AS0634814424

Description	PCS	Pd ca	Qt��	#PLT	#����	VendeurOrg
#���� m���	# lev���				����.orig#Coul	
	5	240.000	218	199868	0529485	017 US
					99 KG	

1842811

D366363 109604B9

Total: 5 240.000 218

99 KG

Poids total:

218 LVR

Poids total:

99 KG

#Total paquets:

1

Commentaires connaissance:

CERTIFICATE OF COMPLIANCE MEETS
THE MATERIAL DETAILED ABOVE MEETS YOUR ORDER
REQUIREMENTS AND GRADE STANDARDS AS DESCRIBED
PLEASE REFER TO MILL TEST REPORT ATTACHED.

AUTHORIZED BY:

Rainone Date 1/26/15

Anne Rainone
Administration



PR         PAR ☒ PORT             ☐ PORT            
CHARGES

INST. VOITURIER/DRIVER INSTRUCTIONS

VALEUR (  200   max        d'avis contr    )
VALUATION (Max \$ 2000 unless otherwise stated)
VALUER D         DE L'EXP        
DECLARED VALUE OF SHIPMENT
RE     PAR/RECEIVED BY

VOITURIER/DRIVER

SHIP TO: SAMUEL BAIE D'URFE(SHIP TO) 21525 CLARK-GRAHAM BAIE D'URFE, PQ, CA H9X 3T5
SOLD TO: SAMUEL LAVAL 2225 FRANCIS HUGHES LAVAL, PQ, CA H7S1N5

**KAISER
ALUMINUM**
Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4355126

CUSTOMER PO NUMBER: C69364	WORK PACKAGE:	CUSTOMER PART NUMBER:	SHIP RUN/LOAD: 103068/2	GOV'T CONTRACT NUMBER:		
KAISER ORDER NO: 1182429	LINE ITEM: 4	SHIP DATE: 3-DEC-2014	ALLOY: 2024	CLAD: BARE	TEMPER: T3	PRODUCT DESCRIPTION: HT Flat Sheet
WEIGHT SHIPPED: 6649 LB	QUANTITY: 148 PCS EST.	TRUCK B/L #: 2051086	GUAGE: 0.0630 IN (1.6002 A.M)	DIAMETER/WIDTH: 48.000 IN (1219.2 MM)	LENGTH: 144.000 IN (3657.6 MM)	

MHU 1842811: LOT 109604B9: 51 pieces; *0366363*
MHU 1842813: LOT 109604B9: 97 pieces; *0366364*

Certified Specifications

AMS 4037/RevP
CMMP 019/RevD

AMS-QQ-A-250/4/RevA
CMMP 025/RevU

ASTM B 209/Rev10

Test Code: 1504

Test Results

Lot: 109604B9 Cast 706 Drop 83 Ingot 1 Melted in USA

(ASTM E8/B557)
(EN 2002-1)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	✓ 66.1 : 66.2 (456 : 456)	✓ 44.1 : 44.2 (304 : 305)	✓ 17.9 : 18.6



(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual(wt%)	0.08 ✓	0.20 ✓	4.6 ✓	0.58 ✓	1.3 ✓	0.01 ✓	0.10 ✓	0.02 ✓	0.01	0.01	TOT. 0.04 ✓

ALLOY LIMITS

	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024												
MIN(wt%)	0.00	0.00	3.8	0.30	1.2	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX(wt%)	0.50	0.50	4.9	0.9	1.8	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder





Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4355126

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC (Kaiser), is ISO 9001:2008/AS9100C certified and hereby certifies that all material shipped under this order:

- has been inspected, tested, and found to be in conformance with the requirements of the specifications indicated herein. For material thicknesses outside specification limits, mechanical properties are as shown herein and chemical composition meets specification requirements.
 - was melted in the United States of America or a qualifying country per DFARS 225.872-1(e), was manufactured in the United States of America, and meets the requirements of DFARS 252.225 for domestic content.
 - has been thermally processed in compliance with AMS 2772, where applicable.
 - is mercury free, within the limits of detection of ASTM E1251 (≤ 1 ppm).
 - is in compliance with RoHS 2, European Union Directive 2011/65/EU.
 - is in compliance with and regularly monitors any updates to the European Chemical Agency, ECHA, REACH regulations, (EC) n°1907/2006.
 - is free of Conflict Minerals, as defined in Section 15.2 of the Dodd-Frank Act.
- Any warranty is limited to that shown on Kaiser Aluminum's standard general terms and conditions of sale. Test reports are on file, subject to examination. Test reports shall not be reproduced except in full, without the written approval of the Kaiser Aluminum laboratory. The recording of false, fictitious or fraudulent statements or entries on the certificate may be punished as a felony under federal law.

JAMES HEMENWAY, LABORATORIES SUPERVISOR

